

Shp 29/04

Dart Aerospace Ltd.

Date: Wednesday, 23/04/2008 7:02:34 AM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SUPPORT BRACKET
Job Number : 38766	
Estimate Number : 10260	
P.O. Number :	Part Number : D23623
This Issue : 23/04/2008 S.O. No. :	Drawing Number : D2362 REV E1
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : E1
Previous Run : 37459	Material :
Written By :	Due Date : 29/04/2008 Qty: 8 Um: Each
Checked & Approved By :	
Comment : Est: G 00.05.18 Added inspection level 8 EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2265	Step Bracket
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Step Support

Pick:

Qty	Part Number	Description	Batch
1	D2265	Step Support	37477

Ind 2.04.25 (8)

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: Machine per folio D2362-3

EC 08-04-28 8

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: Inspect Level 2

EC 08-04-28 8

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

Ind 08/04/28 (8)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr

EC 08-04-28 38766

6.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

Powder Coat Gloss White (Ref 4.3.5.1) as per Dart QSI 005 4.3

Ind 08-04-28 (X)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 23/04/2008 7:02:34 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT BRACKET

Job Number: 38766

Part Number: D23623

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

BR 08-04-28

②

8.0

D23971

Rubber Cushion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Rubber Cushion

Pick:

Qty Part number

Description

Batch

1

D2397-1

Rubber

B38053 (12)

B36117 (7x)

SB 08/04/29

9.0

D23973

Rubber Cushion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Rubber Cushion

Pick:

Qty Part number

Description

Batch

1

D2397-3

Rubber

B36118 (7x)

B38054 (12)

SB 08/04/29

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Bond rubber D2397-1 followed by D2397-3 using contact cement
as per Dwg D2362

Batch M 10-7860

48
ml 08/04/29

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/04/29 (48)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 478

8/4/29

SP

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/29

Job Completion



MF 08-04-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART



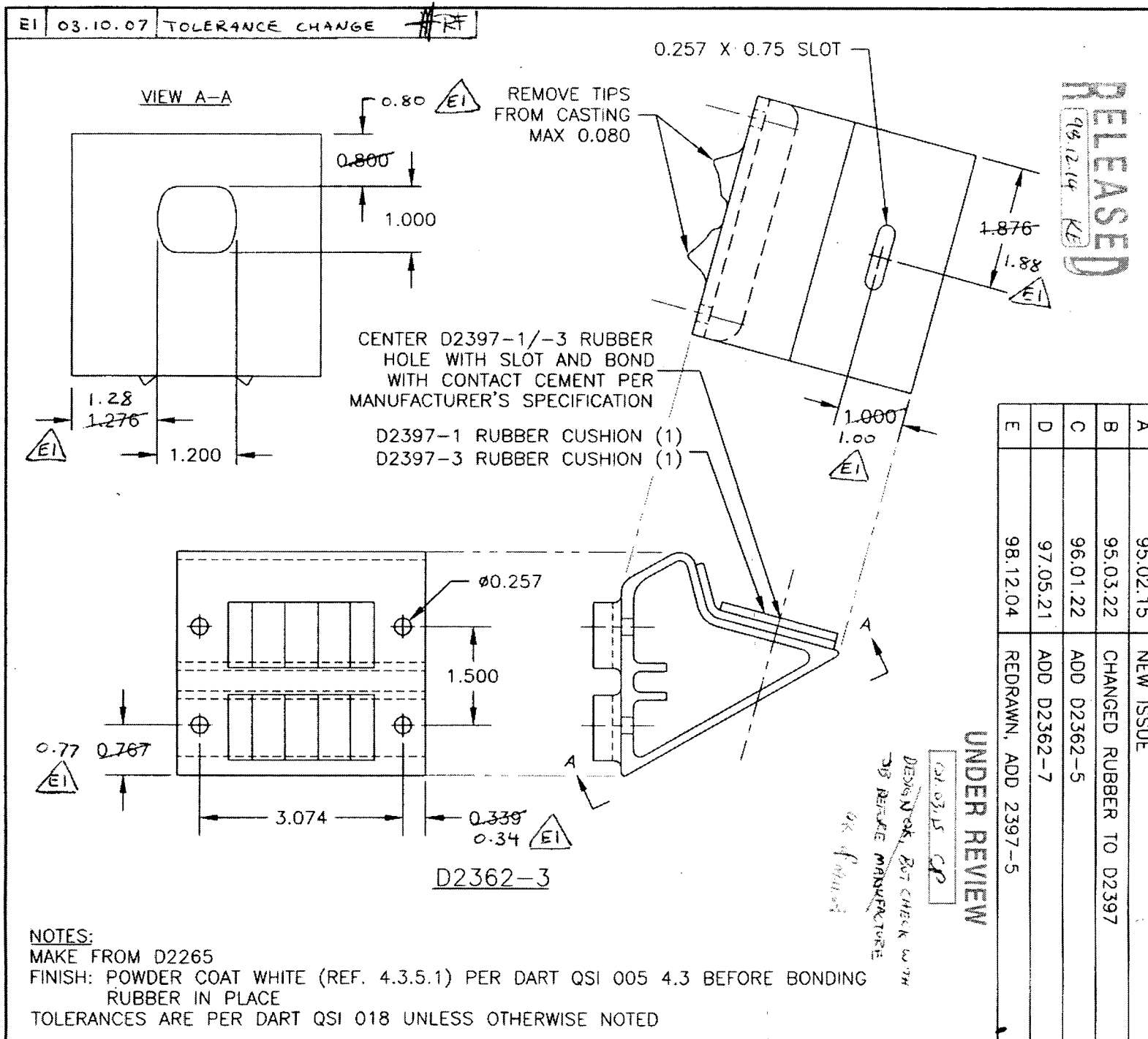
RELEASED
98.12.14 KE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	REV. E
BW	APPROVED	DRAWING NO. D2362	SHEET 1 OF 3
CHECKED	DATE	TITLE	SCALE
KE	98.12.04	STEP SUPPORT BRACKET	1:2
A	95.02.15	NEW ISSUE	
B	95.03.22	CHANGED RUBBER TO D2397	
C	96.01.22	ADD D2362-5	
D	97.05.21	ADD D2362-7	
E	98.12.04	REDRAWN, ADD 2397-5	

UNDER REVIEW

03.03.15 CP

DESIGN OK, BUT CHECK WITH
DIP BONDING MANUFACTURE
OK if required



NOTES:

MAKE FROM D2265

FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BEFORE BONDING RUBBER IN PLACE

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

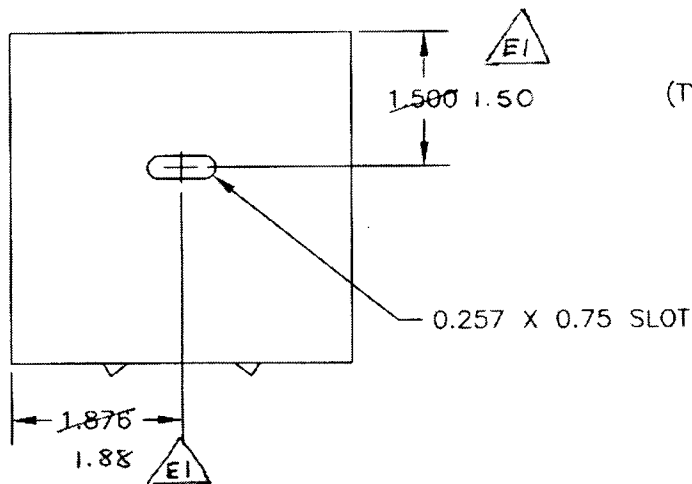
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DART



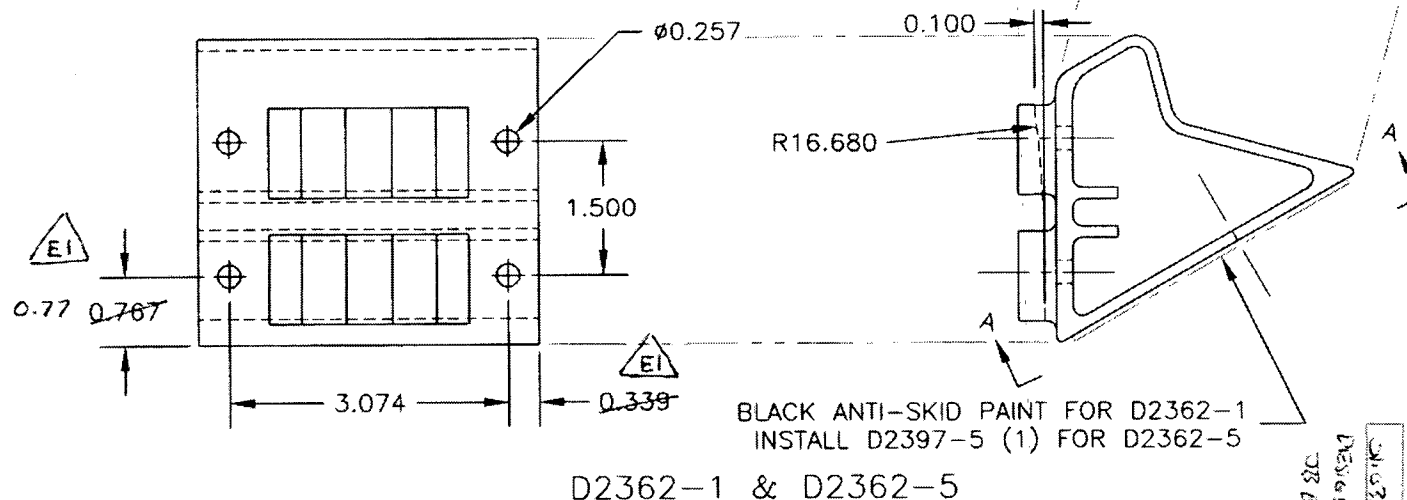
DESIGN	DRAWN BY	DART AEROSPACE LTD
BW	CP	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
KE	CP	D2362
DATE	TITLE	REV. E
98.12.04	STEP SUPPORT BRACKET	SHEET 2 OF 3
		SCALE 1:2

VIEW A-A



MACHINE TO
R1.100
(TYP 2 PLACES)

REMOVE TIPS
FROM CASTING
MAX 0.080



BLACK ANTI-SKID PAINT FOR D2362-1
INSTALL D2397-5 (1) FOR D2362-5

D2362-1 & D2362-5

NOTES:

MAKE FROM D2265

D2362-1: BLACK ANTI-SKID PAINT PER DART QSI 005 4.4

D2362-5: INSTALL D2397-5 RUBBER CUSHION. ALIGN RUBBER HOLE WITH SLOT
AND BOND USING CONTACT CEMENT PER MANUFACTURER'S SPECIFICATION

FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER QSI 005 4.3

BEFORE ANTI-SKID PAINT OR BEFORE INSTALLING D2397-5

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
1998.12.14
UNDER REVIEW

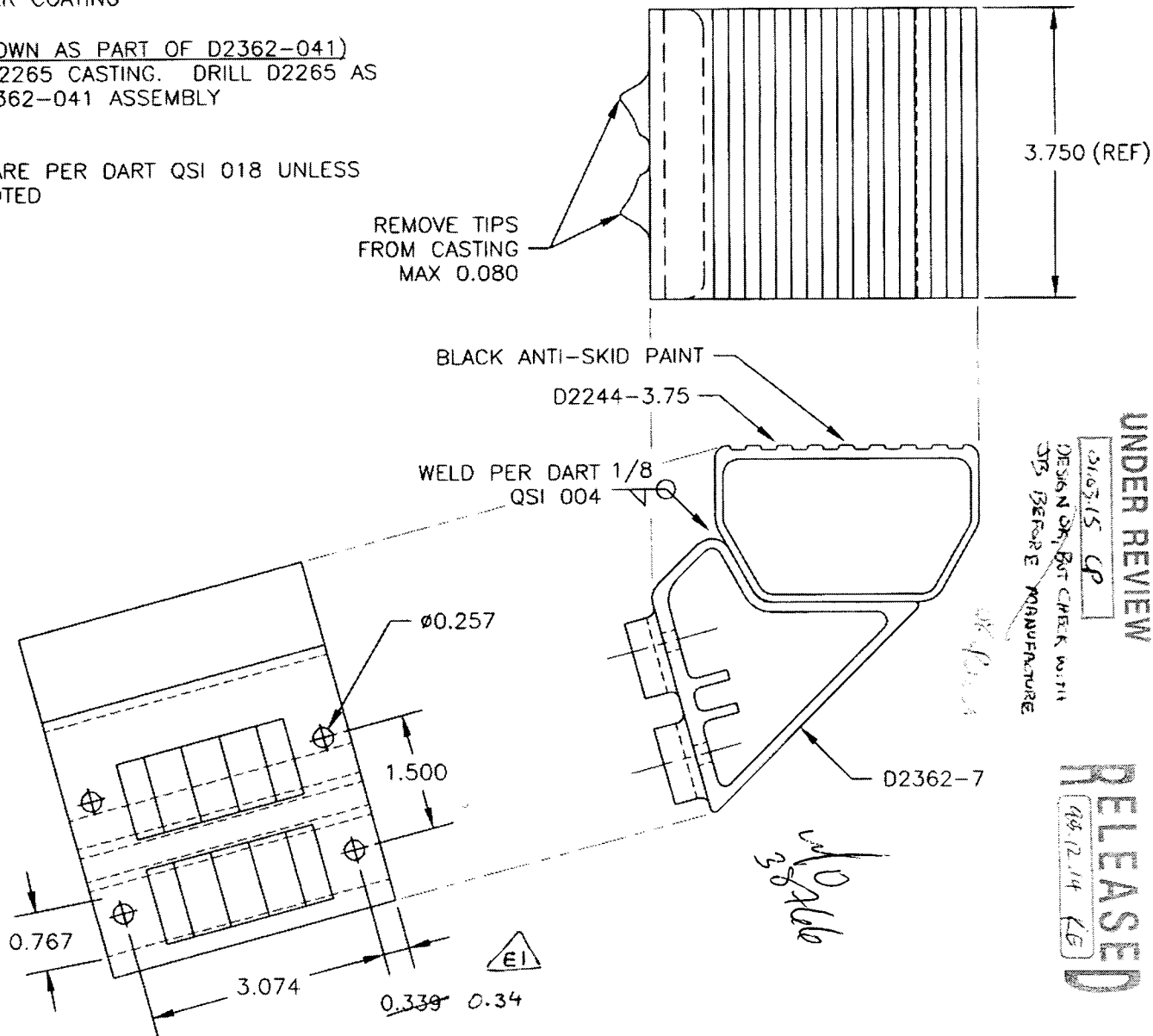
DESIGNED BY CP
08 BEFORE MANUFACTURE
OK 1/10/99

[illegible]

FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER
QSI 005 4.3
ANTI-SKID PIAANT PER QSI 005 4.4 AFTER
POWDER COATING

D2362-7 (SHOWN AS PART OF D2362-041)
MAKE FROM D2265 CASTING. DRILL D2265 AS
SHOWN IN D2362-041 ASSEMBLY

NOTES:
TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED



DART



DESIGN	DRAWING BY		DARI AEROSPACE LIB	
BW			HAMKESBURT, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. E	
<i>KE</i>	<i>HA</i>	D2362	SHEET 3 OF 3	
DATE	TITLE		SCALE	
98.12.04	STEP SUPPORT BRACKET		1:2	

UNDER REVIEW

98-12-14 KE

0105/15 CP
DESIGN OK, BUT CHECK WITH
JTS BEFORE MANUFACTURE

Copyright 1995 by DART AEROSPACE LTD

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Ln

5

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1

DART Aerospace Ltd

#R08-50

CUSTOMER RETURN

Initiator: Jan Kerr
 Company: Worldwide Maint.
CWORLD
 Phone No. 425-793-8400

Date: May 9/08
 Invoice # 6443
 Order Entry # 5934

Attach Copy of DHS Return Authorization # 401

Reason for return: Customer - M's order understood Catalogue
ordered correct Bracket.

Receiving: AO
 Date Received: 8/8/23 Freight Company: FedEx Ground Prepaid Collect

#	Part #	Batch #	Description	Distribute to QC	
				Advise QA	Date:
4	D2362-3	38766	Step Support Bracket	<u>DAVE</u>	<u>8/8/23</u>

Condition of packaging: Good Photograph required: yes ☒ no

Paperwork attached: P/S ☒ Invoice ☐ ARC ☐ Docs ☐ Other ☐

QC: Quarantine: Location: Condition of Part: good

Inspect: Initial:

#	Part #	Batch #	QC Comments	QC Approval		Scrap
				Initial	W/O #	
4	D2362-3	38766	Return to stock as per WO	<u> </u>	<u>39471</u>	

QA Coordinator: Advise GM as to findings: Initial: Date:

Comments:

Issue credit: yes ☐ no ☐

GM Approval: Date:

Invoice Amount:
 Less Replacement:
 Restock Fee:
 Freight:
 Net Credit:
 DHS ☐ Customer ☐

QA: Enter into Q-Pulse with reason for return & File original. Signed: Date:

Copy of Customer Return to stay with work orders and another copy to be filed with customer credit